

Work Order ID 124757

September-23-14 7:54:06 AM

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Item ID: D2429-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring Clip Ass'Y
 Start Date: 9/23/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/03/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1409-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2429	Rev C1								

100	FLOW WATER JET	0.00				(22)	2/02 14/09/30	
100								
Waterjet	Memo	0.00						
FLOW CNC Waterjet	1-Cut as per Dwg D2429*****Make 2 parts per -041 assembly***** Dwg Rev: <u>C1</u> Prog Rev: <u>C1</u>							
	2-Deburr if necessary							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				(22)	2/02 14/09/30	
110								
QC	Memo	0.00						
Quality Control								
120	QC8- Inspect parts - second check	0.00				(22)		DAS
120								38
QC	Memo	0.00						0.80 14-01-01
Quality Control								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
160									14-10-16
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>S1007</u>	0.00							
170									MLJ 14-10-16
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									14/10/17
QC	Memo	0.00							
Quality Control									

14-10-16

Picklist Print

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Work Order ID: 124757

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Parent Item: D2429-041

D2429-041

Parent Item Name: Spring Clip Ass'y

Start Date: 9/23/14

Required Date: 10/03/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.03.06 Added note at step 7 NG
IPP Rev:E Now on Waterjet 06-06-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased				150	sf	271.0319	0.0068	1			
M304S20GA									**			12 14/09/30	
304/316 .040 Sheet													

Location	Loc Qty	Loc Code
MAT020	271.0318948	
m126852	0.31	
m127454	26.1018948	
m128435	81.14	
m129128	0.5	
m129845	34.98	
m130345	128	
	364	

MS20470AD4-5 Purchased No

MS20470AD4-5

RIVET, UNIVERSAL HEAD

Location	Loc Qty	Loc Code
ST312	2465	
m128401	1653	
m128813	812	

NAS1149DN616J Purchased No

NAS1149DN616.J

Washer

Location	Loc Qty	Loc Code
ST276	389	
M127726	389	

14/10/15

M126926

DAS 36 9-89

14/10/15

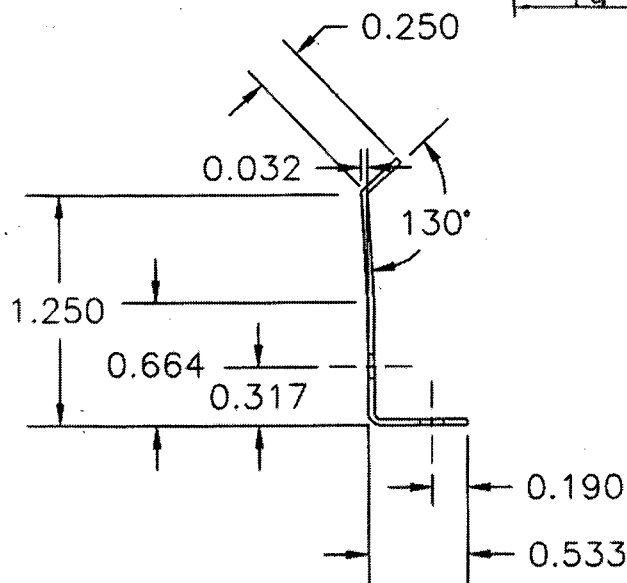
DAS 36 9-89

22

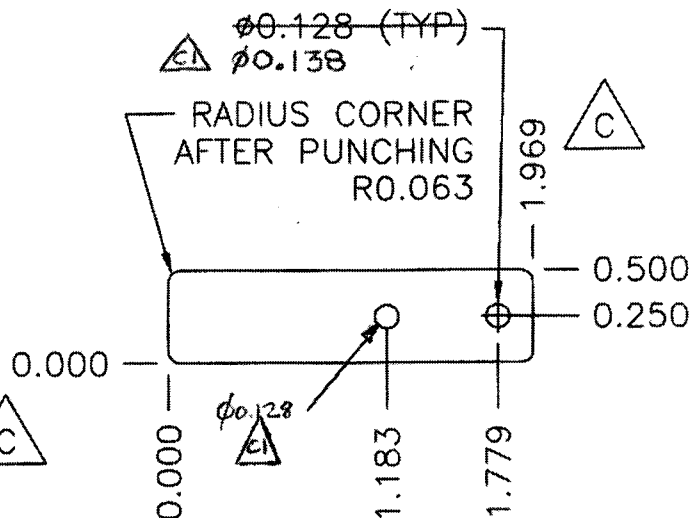


DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26	TITLE SPRING CLIP		SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	Ø0.138 WAS Ø0.128	

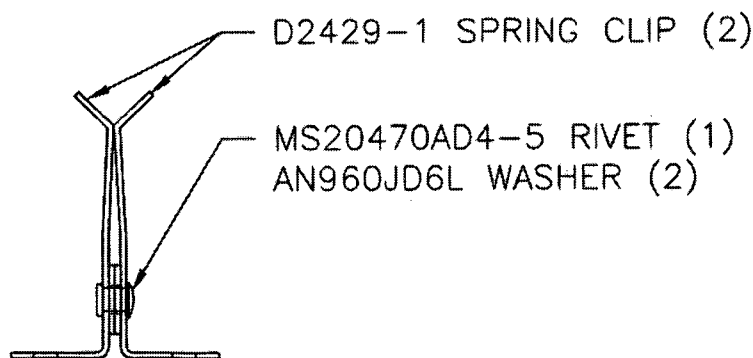
RELEASED
00.06.27 #



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 124757 MLS
(4-9-23)

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